

Date: Tuesday, 4/18/2006 9:58:40 AM
User: Kim Johnston

Process Sheet

SPLIT

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LUG	
Job Number	: 26647 A				
Estimate Number	: 10337				
P.O. Number	: N/A		Part Number	: D28073	
This Issue	: 4/18/2006	S.O. No.	: N/A	Drawing Number	: D2807 REV C
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: C	
Previous Run	: 26625		Material	: N/A	
Written By	: <u>See comment below</u>		Due Date	: 4/30/2006	
Checked & Approved By	: <u>KJ 06.04.18</u>		Qty:	<u>56</u>	
Comment	: Est A 05.06.02 New Issue KJ/JLM		Um:	Each	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M303R0750	303 Round Bar .75" 
	Comment: Qty.: 0.1094 f(s)/Unit Total : 6.5646 f(s) Material: 303 Round Bar Ø0.750" (M303R0.750)	1100806 Batch: <u> </u>  <i>JF 06/05/26</i>
2.0	HARDINGE	HARDINGE CNC LATHE SMALL 
	Comment: HARDINGE Turn as per Folio FA529 and Dwg D2807 Dwg Rev: <u>C</u>	
	2-Deburr	<i>MS 06105127 54 6000</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<i>MS 06105127 54 6000</i>
4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 
	Comment: Haas #1 Machine as per Folio FA528 and Dwg D2807 Dwg Rev: <u>C</u> Folio Rev: <u>AA</u> <i>N/A machined manually</i>	 <i>JF 06/07/31 / J.F. 06/07/31 54</i>
5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<i>JF 06/07/31 / J.F. 06/07/31 54</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes Yes No No DQA: SD Date: 06/18/02
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 QC8

SECOND CHECK



Comment: SECOND CHECK

SG 06107131 54

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST387

LB 06/08/01

SG 06107131

54

8.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SG 06/08/02

Job Completion



(Loc) 06108102

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

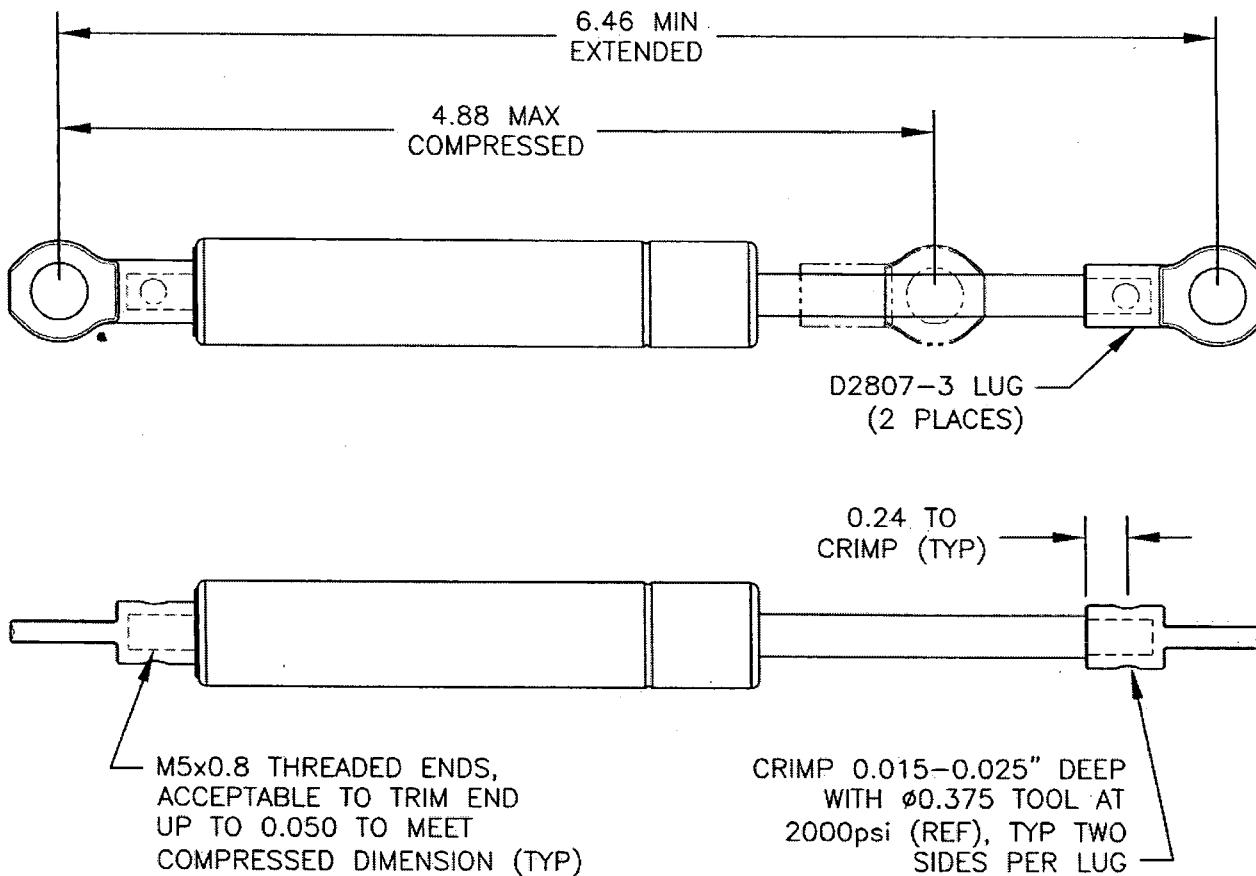
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

RELEASED
4/25/06.16



D2807 GAS SPRING

1) SPECIFICATION: SS GAS SPRING
 ACCEPTABLE LOAD RANGE IS 25 lb MIN TO 45 lb MAX
 M5x0.8 THREADS

2) SUPPLIER: ArvinMeritor Motion Control Systems, Leicester, UK
 P/N: SXF6S6050080S6L-115N
 (REF: 80mm LONG CYLINDER, 50mm STROKE, 115N LOAD)

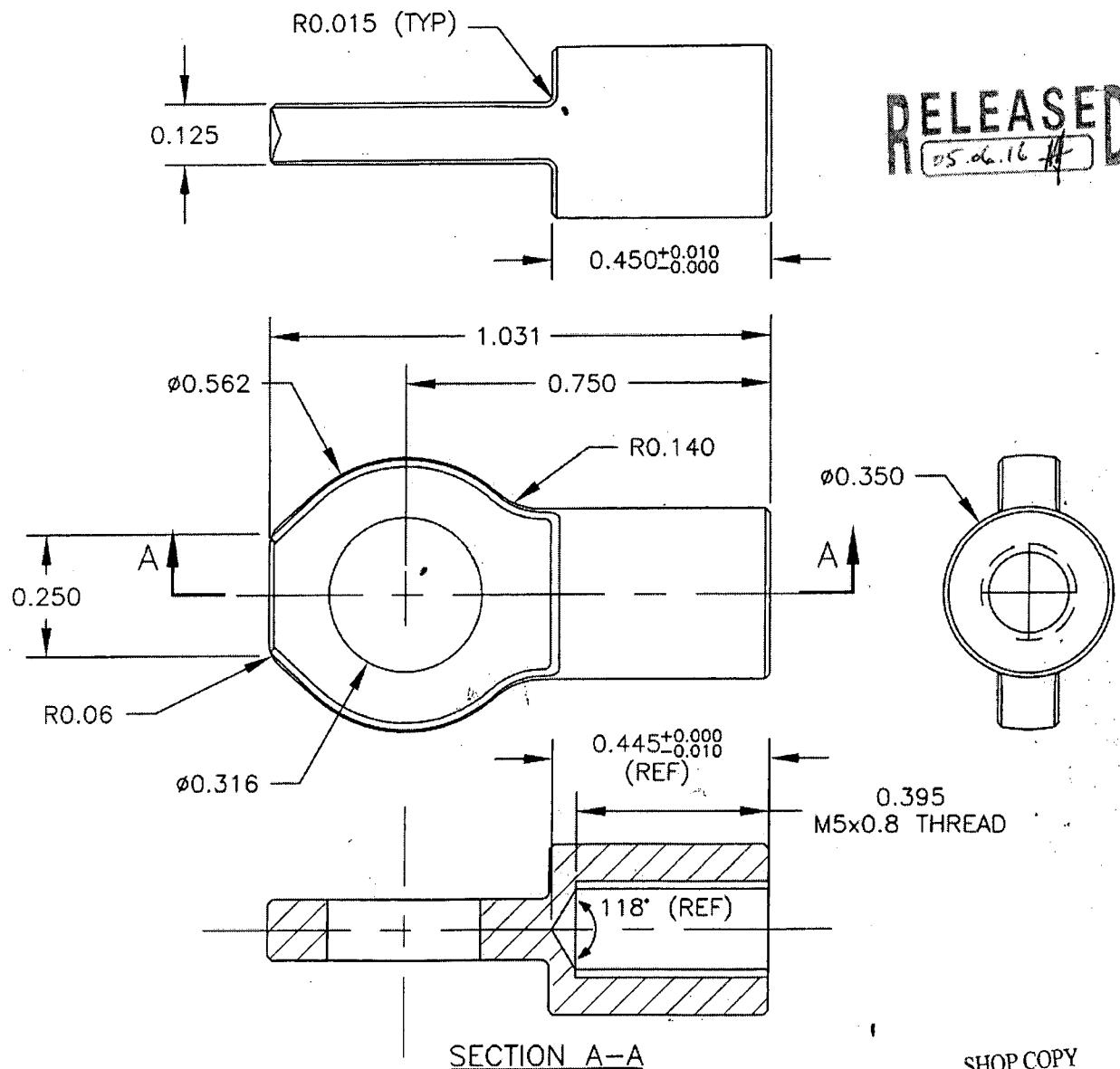
3) ALLEN DIMENSIONS ARE IN INCHES
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

WORK ORDER NO. 2647
 SHOP COPY
 RETURN TO
 ENGINEERING
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 SUBJECT TO AMENDMENT
 WITHOUT NOTICE

DESIGN CP		DRAWN BY CP	DART AEROSPACE LTD		
			HAWKSBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	REV. C		
DATE			SHEET 1 OF 2		
05.05.25		D2807	SCALE		
A	00.11.03	NEW ISSUE	TITLE	1:1	
B	05.03.16	ADD FINISH	GAS SPRING		
C	05.05.25	CHANGE SPRING TO SS, ADD -3 LUG			

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2807	REV. C SHEET 2 OF 2
DATE 05.05.25		TITLE GAS SPRING	SCALE 3:1

**D2807-3 LUG**

- 1) MATERIAL: AISI 303 ROUND BAR (REF DART SPEC. M303R)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.015
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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WORK ORDER
NO. *26647*



DART AEROSPACE LTD	Work Order:	26647
Description: Gas spring	Part Number:	D2807-3
Inspection Dwg: 2807 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by:	M& / M	Audited by:	SJ / JRL	Prototype Approval:	N/A
Date:	06/05/27	Date:	06/05/29	Date:	

Rev	Date	Change	Revised by	Approved
A	06/06/12	New Issue	KJ/RF	

1

115.000.00

100 12
- 50 2.
- 110 1.
- 110 1.
- 110 1.